

# Work Order ID 54652

December 15, 2009 1:28:45 PM



Page 1

Item ID: D3923-1

Revision ID:

Item Name: Angle

Start Date: 12/15/09 Start Qty: 15.00

Required Date: 12/16/09 Req'd Qty: 15.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3923

A

145

0.00



Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

15 X D3923-1 B48624

U 9-12-15

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 09-12-16 (15)

# Work Order ID 54652

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Page 2

Item ID: D3923-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 12/15/09 Start Qty: 15.00



Cust Item ID:

Required Date: 12/16/09 Req'd Qty: 15.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

POWDER COAT:

Start Time: 11:30

Oven Temperature: 320°

Finish Time: 12:00

0.00

BR 09-12-16

15

170

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

=> M 09-12-16

VIS

Ø

180

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Packaging

Memo

0.00

9/12/10

15 SP

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Item ID: D3923-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 12/15/09 Start Qty: 15.00



Cust Item ID:

Required Date: 12/16/09 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/12/17 *[Signature]*

*MF*  
09-12-16

# Picklist Print

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Page 1

Work Order ID: 54652

Parent Item: D3923-1

Parent Item Name: Angle

Comments: Rev:A new issue

Start Date: 12/15/09

Required Date: 12/16/09

Start Qty: 15.00

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3923-1		Manufactured	No				Each	13.0000	15.0000			



Angle

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

48624

13

MF 09-12-14

8 7 6 5 4 3 2 1

D

C

B

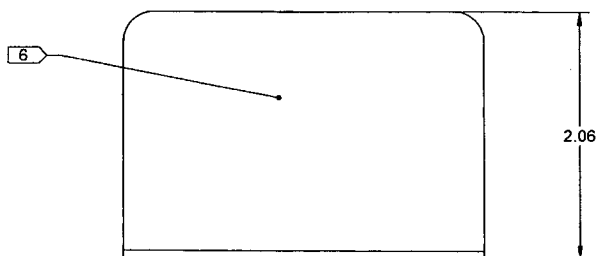
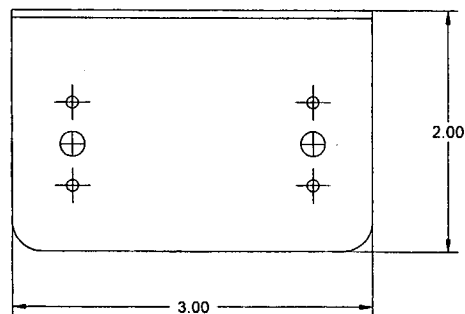
A

D

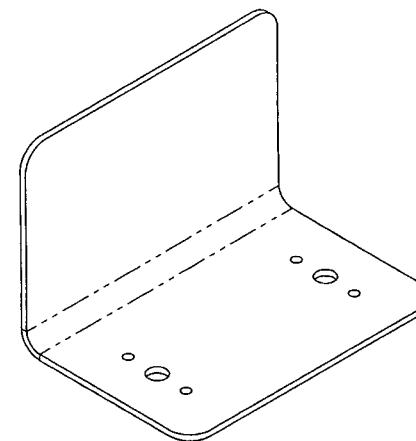
C

B

A



R0.16



who 54652

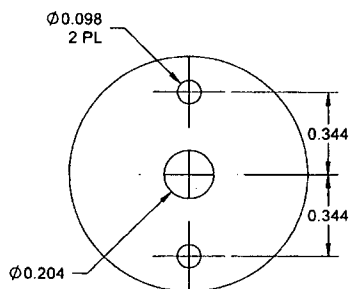
**D3923-1 ANGLE**  
MADE FROM D3923-1F

**RELEASED**  
2009-08-28  
*MP*

**NOTES:**

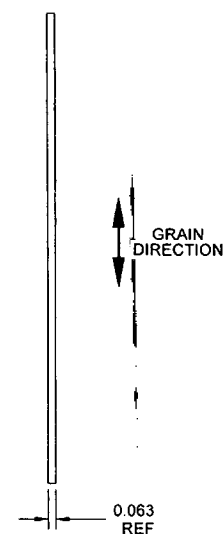
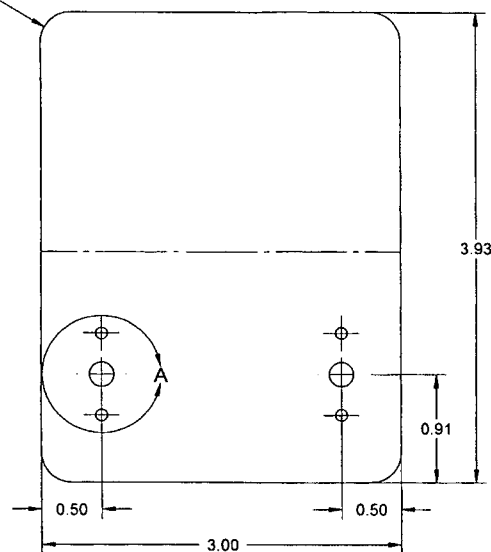
- 1) MATERIAL: MADE FROM D3923-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3923-1" USING A WHITE FINE POINT PAINT MARKER
- 7) WEIGHT: 0.07 lbs

A		NEW ISSUE		09.03.30	
REV.		DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN				SHEET 1 OF 2	
CHECKED	<i>ALS</i>	DRAWING NO. <b>D3923</b>		SCALE	
MFG. APPR.	<i>ES</i>	TITLE <b>ANGLE</b>		NTS	
APPROVED	<i>MP</i>	DATE <b>09.03.30</b>		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DE APPR.	<i>MP</i>				



**DETAIL A 86**  
TYP  
SCALE 2X

R0.25  
TYP



*Sub 52*

**D3923-1F FLAT PATTERN**

**RELEASED**  
2009-08-28  
*NA*

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.063)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN	<del>ES</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>ES</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. A
MFG. APPR.	ES	D3923	SHEET 2 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ANGLE	NTS
DATE	09.03.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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